

Blue

Work Order ID 55773

February 1, 2010 10:18:32 AM

Page 1

Item ID: D2731-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 1/29/10 Start Qty: 20.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 1/20/10

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2731

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to .82"

Batch B45800

mk 10/02/14

20

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling

mk / S.F. 10/02/17

20

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mk / S.F. 10/02/17

20

0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 55773

February 1, 2010 10:18:32 AM

Page 2

Item ID: D2731-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 1/29/10 Start Qty: 20.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

H.A 10/02/18

20 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Bk 10-02-19

20 0

Hand Finishing

155

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

m 10 02 25 (20)

Spray Painting

Prime Delfleet Blue B 110918
Paint Delfleet Blue B 113171
Clear Delfleet B 113314

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 55773

February 1, 2010 10:18:32 AM



Page 3

Item ID: D2731-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 1/29/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

25 10-07-01 (20)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PC 10/3/01 (20)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/02
mc
10-3-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

February 1, 2010 10:18:36 AM

Page 1

Work Order ID: 55773

Parent Item: D2731-7

Parent Item Name: Mounting Lug

Start Date: 1/29/10

Required Date: 2/08/10

Comments: IPP ☐ D ☐ 00.05.19 ☐ Added inspect level 8, removed P/O powder coating ☐ EC ☐

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2731-7P | N | Purchased | No | | | 100 | Each | 0.0000 | 20.0000 | | | |
| LUG | A | | | | | | | | | | | |
| D2423 | | Manufactured | No | | | 110 | f | 604.4578 | 1.4379 | | | |
| Lug Extrusion | | | | | | | | | | | | |

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

604.4578379

43722

175.629406

44529

5.7731

→ 45800

423.055332

1.4379 ml 10/02/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 55773 |
| Description: Lug | | Part Number: | D2731-7 |
| Inspection Dwg: D2731 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 4.450 | +/-0.010 | 4.453 | ✓ | | | |
| 1.41 | +/-0.030 | 1.415 | ✓ | | | |
| 0.306 | +/-0.010 | .313 | ✓ | | | |
| 0.413 | +/-0.010 | .415 | ✓ | | | |
| 3.700 | +/-0.005 | 3.701 | ✓ | | | |
| 0.375 | +/-0.010 | .375 | ✓ | | | |
| 0.750 | +/-0.010 | .744 | ✓ | | | |
| Ø0.257 | +0.005/-0.000 | .260 | ✓ | | | |
| R1.100 | +/-0.010 | 1.100 | ✓ | | | |
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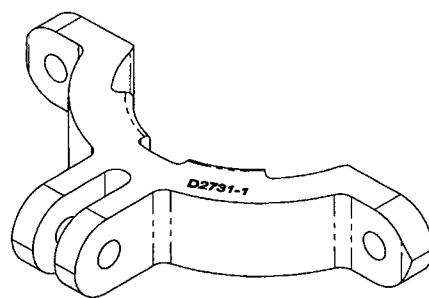
| | | |
|---|--|--|
| Measured by: <i>[Signature]</i> Date: 10/02/17 | Audited by: H.A. Date: 10/02/18 | Prototype Approval: N/A Date: N/A |
|---|--|--|

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------|--------------------------|--------------------|
| A | 04.04.22 | New Issue | KJ/RF | |
| B | 04.05.06 | Dimension change | KJ/RF <i>[Signature]</i> | <i>[Signature]</i> |

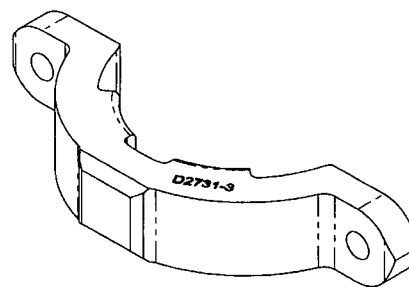
SHOD COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

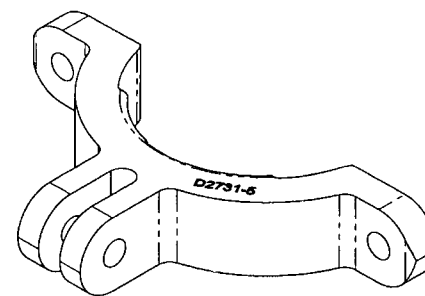
NO. 55273
PS10-201



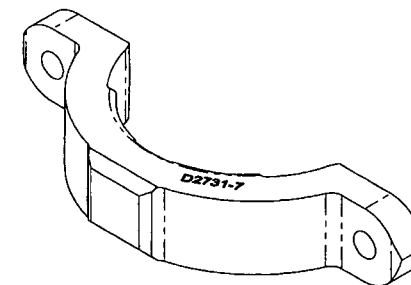
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



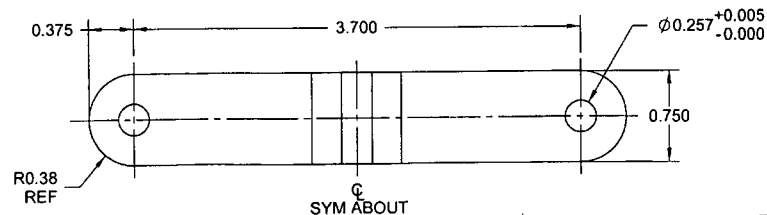
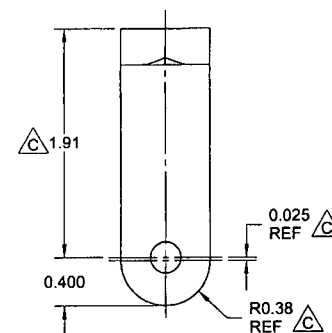
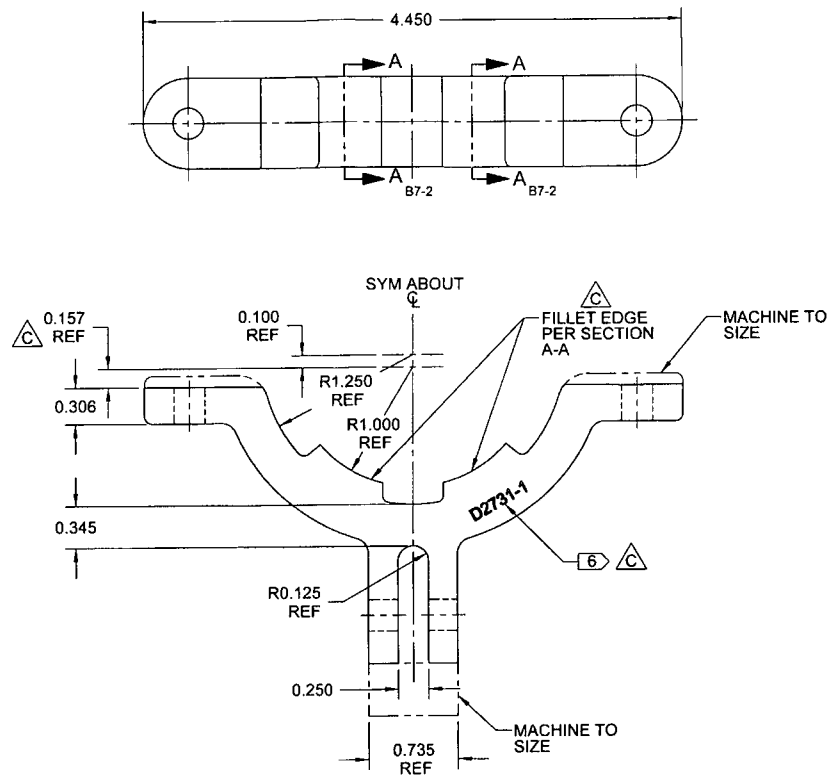
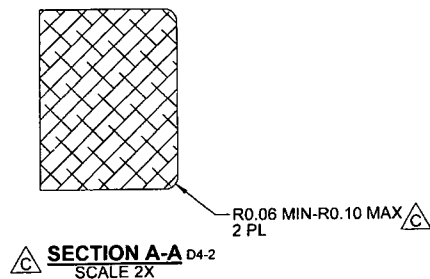
D2731-7 MOUNTING LUG

RELEASED
09/01/19

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

| C | REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION. | AJS | 09.01.19 |
|------------|--|--|--------------|
| B | REVISED DIMENSIONS | KE | 99.07.06 |
| A | NEW ISSUE | KE | 98.05.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | KE | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D2731 | SHEET 1 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNTING LUG | NTS |
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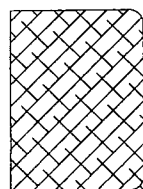
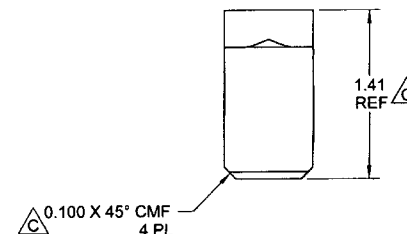
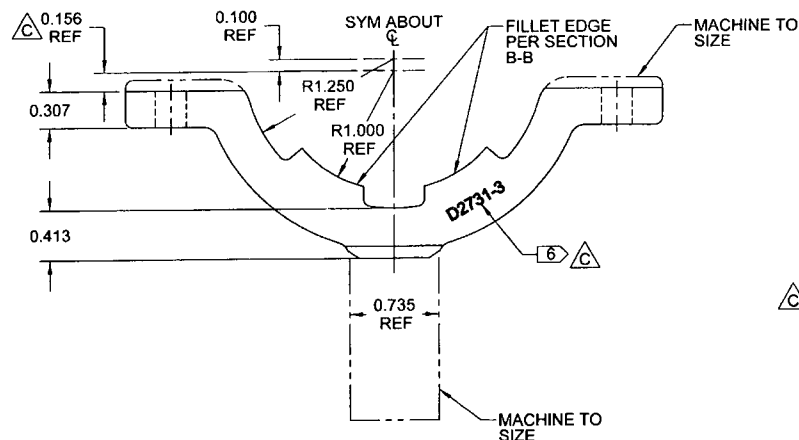
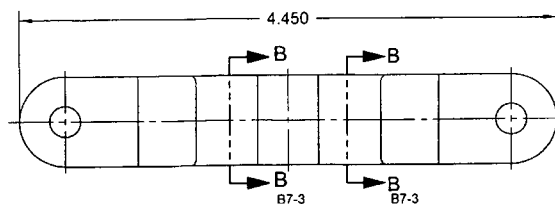


D2731-1 MOUNTING LUG

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09/06/25/47

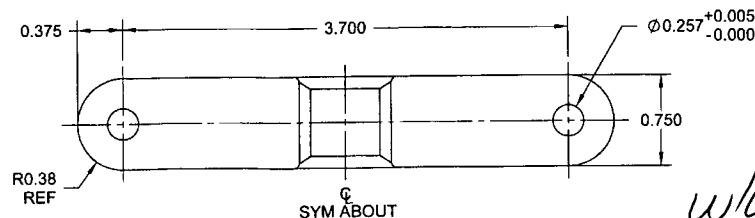
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| DRAWN | AJS | PORT HADLOCK, WA | |
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R0.06 MIN-R0.10 MAX $\triangle C$
2 PL

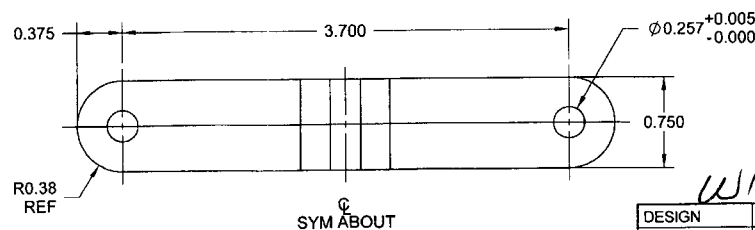
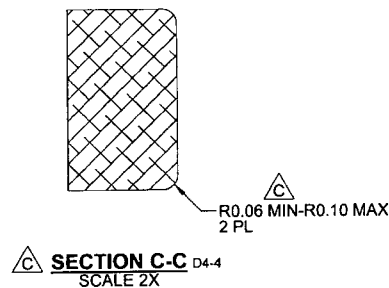
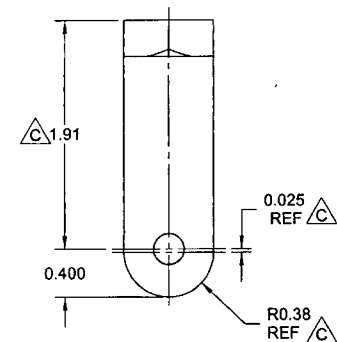
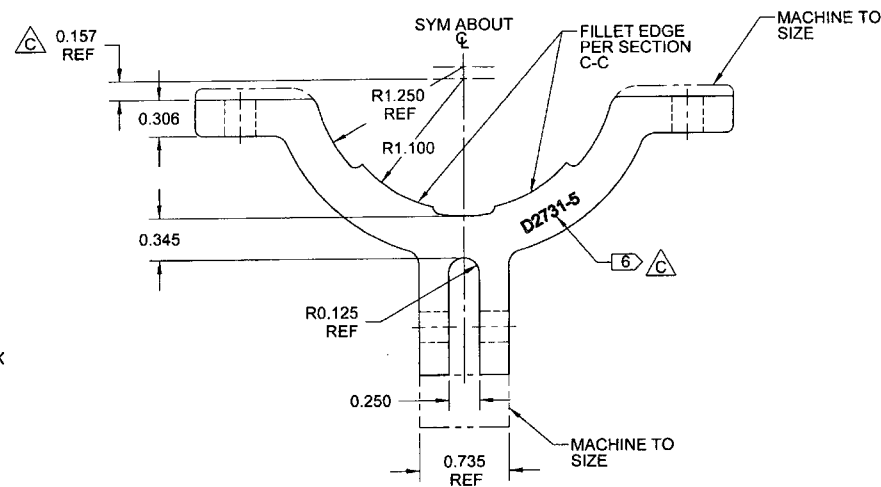
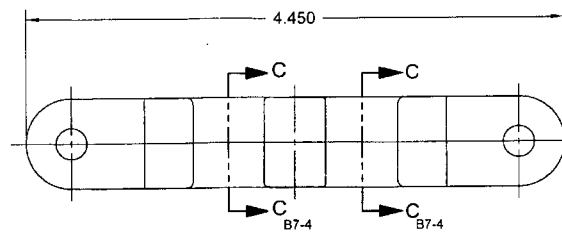
$\triangle C$ SECTION B-B D4-3
SCALE 2X



D2731-3 MOUNTING LUG

RELEASED
09/05/25 M

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| DRAWN | AJS | PORT HADLOCK, WA | |
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| MFG. APPR. | | D2731 | SHEET 3 OF 5 |
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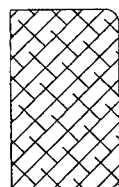
D2731-5 MOUNTING LUG

RELEASED
@ 10/25/10

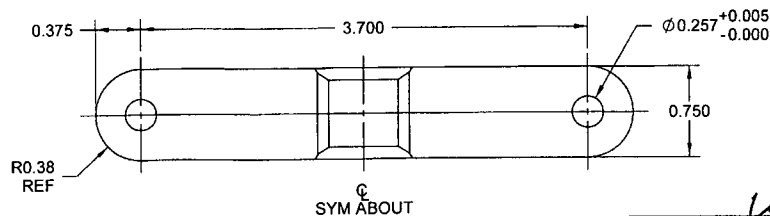
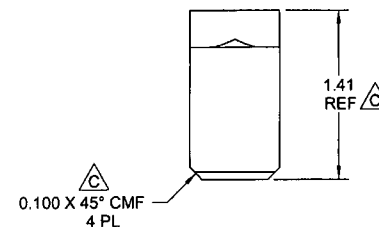
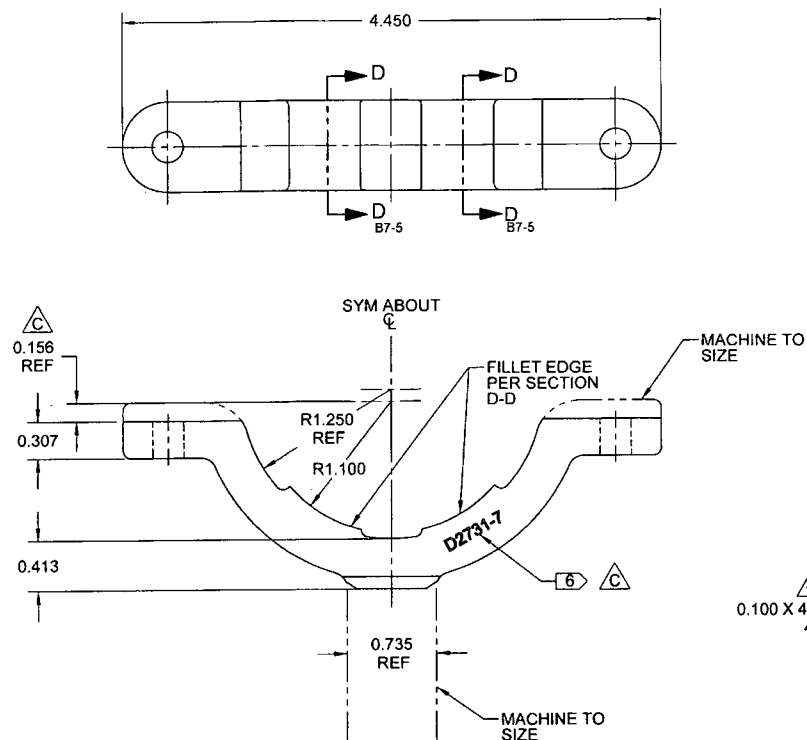
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SECTION D-D D4-5
SCALE 2X



R0.06 MIN-R0.10 MAX
2 PL



D2731-7 MOUNTING LUG

RELEASED
09/16/25/11

W/0 55773

| | | | |
|------------|----------|---|--------------|
| DESIGN | KE | DART AEROSPACE USA, INC. | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D2731 | SHEET 5 OF 5 |
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